

Customer	: CU-DAR001	Dart Helicopters Services	Drawing Name	: SADDLE KIT FOR D206-642-512
Job Number	: 33230			
Estimate Number	: 12894			
P.O. Number	: N/A		Part Number	: K642 512
This Issue	: 6/27/2007	S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: N/A	Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 33098		Material	: N/A
Written By	:		Due Date	: 7/10/2007
Checked & Approved By	:		Qty:	3
Comment	:		Um:	Each
	:	Est Rev: A 05.06.07 new issue EC		

Job Number:

Seq. #:	Machine Or Operation:	Description :
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1.0 DC DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

~~Photocopy bluefile and create labels per PPP K642-512 CHG003.~~

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment: PACKAGING RESOURCE #1**

## Pick Packing Kit

3.0 D206648013 GHW Kit

Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

### Description

Batch

1 D206-648-013 GHW Kit

~~1 D206-642-541(REF)~~

440	D2652	Bushing
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**Comment:** Qty.: 16.0000 Each(s)/Unit      Total : 48.0000 Each(s)

Pick:

Qty Part Number

### Description

Batch

16 D2652

## Bushing

5.0	D2712	Set Screw
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**Comment:** Qty.: 10.0000 Each(s)/Unit      Total : 30.0000 Each(s)

Pick:

Qty Part Number

### Description

Batch

10 D2712

Set Screw

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/27/2007 1:10:56 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-512

Job Number: 33230

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D29322

206 Saddle Right side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2932-2

Saddle

B31252

X

7.0

D29332

206 Saddle Right



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2933-2

Saddle

B31251

X

8.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

B31929

X

9.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

B32469

X

10.0

D29382

206 Saddle Right side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2938-2

Saddle

B29348

✓

B30282

✓

11.0

D29392

206 Saddle Right Side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2939-2

Saddle

B30507

2/7/250

X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SADDLE KIT FOR D206-642-512

Job Number: 33230

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3396-3

Spacer

1326772

1 ✓

13.0

D3407043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-043

Tow Ring

1328926

4

14.0

D34561

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

Washer

1325101

4

15.0

D34571

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3457-1

Washer

1331993

(4)  
32409

7

16.0

AN3C35A



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C35A

Bolt

1418919

4

17.0

AN3C36A



Comment: Qty.: 9.0000 Each(s)/Unit Total : 27.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

9 AN3C36A

Bolt

14107261

7/7/259

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 33230

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN3C41A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN3C41A

Bolt

M103324

X

19.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN4C6A

Bolt

M103344

X

20.0

AN5C11A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN5C11A

Bolt

M104517

X

21.0

AN5C12A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C12A

Bolt

M18912 M103715 M104537

5

2

X

22.0

AN5C13A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C13A

Bolt

M18918 M104603

8

X

23.0

AN5C15A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C15A

Bolt

M100229

7/7/2 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 33230

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN5C32A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C32A

Bolt

M18918

X

25.0

AN5C34A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C34A

Bolt

M18918

X

26.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C35A

Bolt

M18918

X

27.0

AN960C10L

washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

t-1 24 AN960C10L

Washer

M104885

X

28.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

t-1 24 AN960C416L

Washer

M104547

X

7/7/259

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 33230

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN960C516L

Washer

M103341

30.0

MS210433

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

20 MS21043-3

Nut

M104537

31.0

MS210434

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 39.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

13 MS21043-4

Nut

M103603

32.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 MS21043-5Nut

M105418

33.0

NAS1515H3L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H3L

Washer

M102472

34.0

NAS1515H4L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

M104872

7/7/12 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 2 Date: 07/07/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: SADDLE KIT FOR D206-642-512

Job Number: 33230

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

24 NAS1515H4L Washer

35.0

NAS1515H5

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

F1

16 NAS1515H5

Washer

M103691

36.0

NAS1515H5L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

F1

8 NAS1515H5L

Washer

M103691

✓

7/7/250

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

U 5707.05

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP K642-512 CHG008

Location:

7/7/6 50 Draft

39.0

QC21

FINAL INSPECTION/W/O RELEASE



③

Comment: FINAL INSPECTION/W/O RELEASE

20767106

Job Completion



U 07.07.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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